

532

DART AEROSPACE LTD	Work Order:	23860
Description: Rappel Anchor	Part Number:	D2224
Drawing: D2224 Rev. E	Qty:	5

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	AP	05/17/25	5
2	METAL	Cut blanks: 2.660" +.030" / -.010" Note grain direction Material: 7075-T7351 or 7075-T651, 2.5" X 3.2" Batch _____			
3	HAAS	Machine as per Folio D2224			
4	QC	Inspect Level 2			
5	QC	Inspect Level 8			
6	METAL	Tumble Deburr any rough edges after tumbling			
7	QC	Inspect Level 5			
8	PURCHASING	Issue P/O: _____ Red Anodize			
9	QC	Inspect Level 3			
10	STORES	Bag and Tag			
11	EXPEDITING	Close W/O Inspect level 21 Cost / Part: 0 545 05/08/02			

Rev	Date	Change	Revised By	Approved
A	97.05.16	New Issue		
B	93.10.22	Red Anodize, inspection level, drawing revision	KS	
C	99.05.06	New material, Re-format	DM	
D	02.04.23	Add note for grain direction & inspect 8, 21	NG	02-04-26

RELEASED

02/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

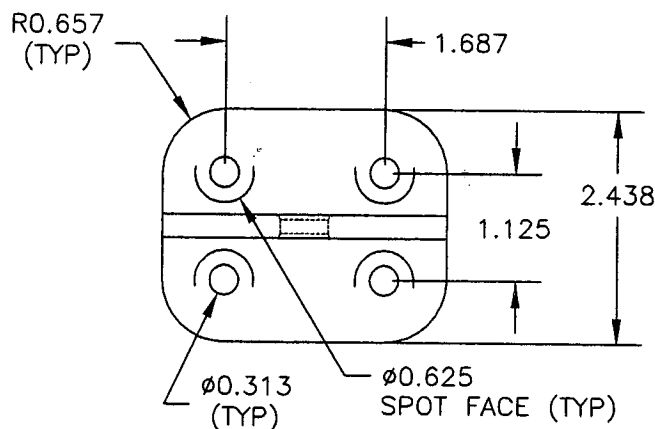
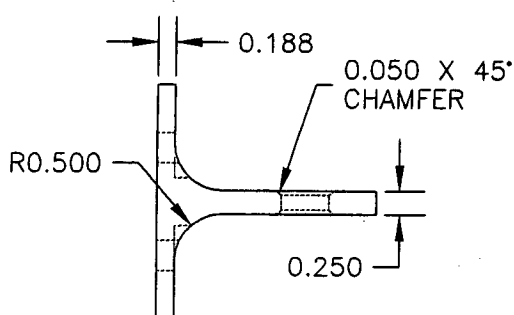
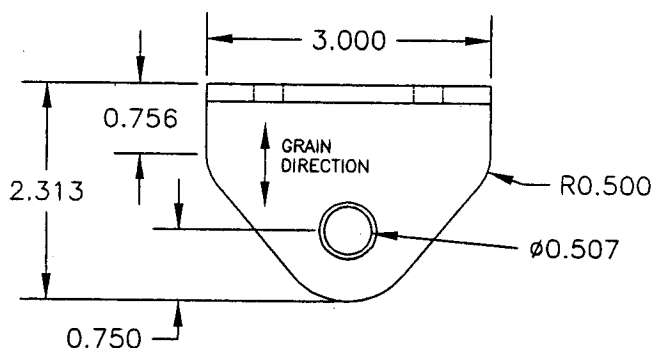
QA: N/C Closed: _____ Date: _____



DESIGN HA	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED HA	DRAWING NO. D2224	REV. E SHEET 1 OF 1
DATE 99.04.29		TITLE RAPPEL ANCHOR	SCALE 1:2
A	94.03.10	NEW ISSUE	
B	95.04.11	D2227 WAS D2216	
C	96.06.17	ADDED D2224-60	
D	97.04.25	CHANGE TO T-SHAPE	
E	99.04.29	REVISE MATERIAL SPECIFICATIONS	

RELEASED
94.09.11 KE

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO ALL
WITHOUT NOTICE
WORK ORDER
NO. _____



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
FINISH : ANODIZE RED PER MIL-A-8625
BREAK ALL UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 22, 2005
07:41 am

Work Order No	: 0023860	Department Code:	
Project Name	: D2224	Burden Flags	: NNNNNNNN
Project For	: WK532	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2224	Invoice Number	:
Description	: Rappel Anchor Assembly	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 5	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 07-21-05		
Est Finish Date	:	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00